

Work Order ID 59115

Wednesday, May 26, 2010 1:24:07 PM

Page 1

Item ID: D2230-3

Accept

Revision ID:

Item Name: Lug

Start Date: 5/26/2010 Start Qty: 120.00

Required Date: 6/4/2010 Req'd Qty: 120.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-5-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev F

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut D2423 extrusion to 0.82"
Batch: 45800

0.00

0.00

ant 10/06/02

120 Ø

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FA927
FOLIO REV: AA
DWG REV: 4
Check for crack while loading into the machine.
2- deburr

0.00

0.00

10.6.3

10/06/06

120 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 5/26/2010 Start Qty: 120.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 120.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10.6.3

120

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10/06/07

120

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

= 7 m-h 10/06/07

120X

W/O:		WORK ORDER CHANGES					
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Work Order ID 59115


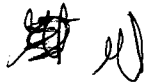

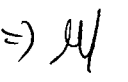

Wednesday, May 26, 2010 1:24:07 PM



Page 3

Item ID: D2230-3 Accept  Setup Start 
Revision ID: Stop 
Item Name: Lug
Start Date: 5/26/2010 Start Qty: 120.00  Cust Item ID:
Required Date: 6/4/2010 Req'd Qty: 120.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		10/06/8		120	0		
170  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M114841 Memo START TIME: 7:45AM OVEN TEMPERATURE: 370°C FINISH TIME: 8:15AM	0.00 0.00		10/06/08		120	0		
180  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				120	0	10-6-8	

W/O:		WORK ORDER CHANGES					
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Page 4

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Accept

Revision ID:

Item Name: Lug

Start Date: 5/26/2010 Start Qty: 120.00

Required Date: 6/4/2010 Req'd Qty: 120.00

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Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 476

0.00

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/6/08 (120)

10/6/09

M 10-6-08

120

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 26, 2010 1:24:12 PM

Page 1

Work Order ID: 59115



Parent Item: D2230-3



Parent Item Name: Lug

Start Date: 5/26/2010

Required Date: 6/4/2010

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC
25 JLM VERIFIED BY:EC
☐

Start Qty: 120.00

Required Qty: 120.00

D2423 Manufactured No 100 f 470.5321 0.0683 8.627368



Lug Extrusion



Location

Loc Qty

Loc Code

MAT06

470.5320795

43722

180

→ 45800

290.532079

8.6274 m 10/06/08

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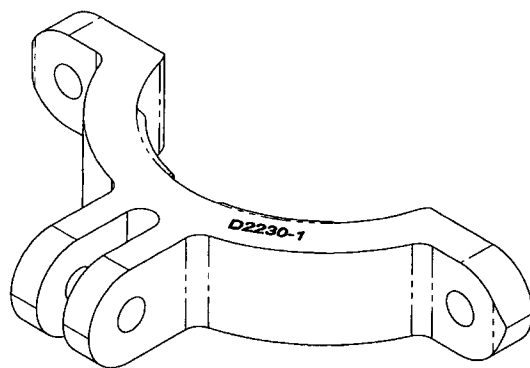
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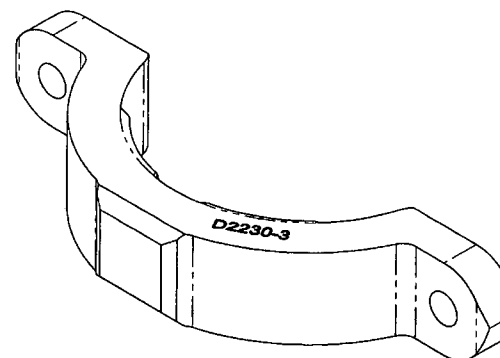
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NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59115

R110-5-26

RELEASED
01/26/15 MJB



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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NOTE: Date & initial all entries

8

7

6

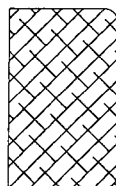
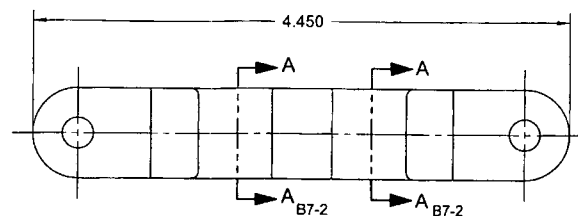
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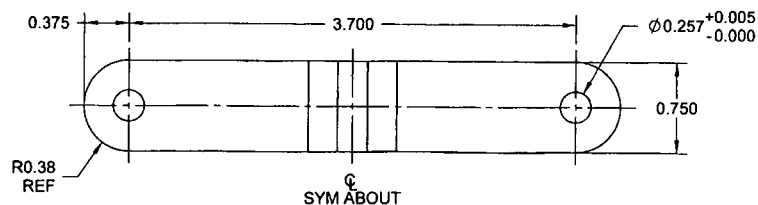
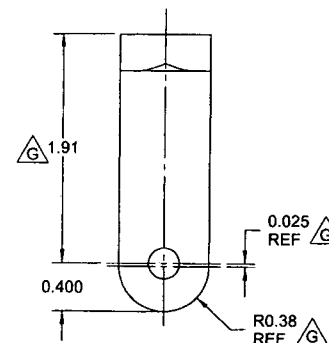
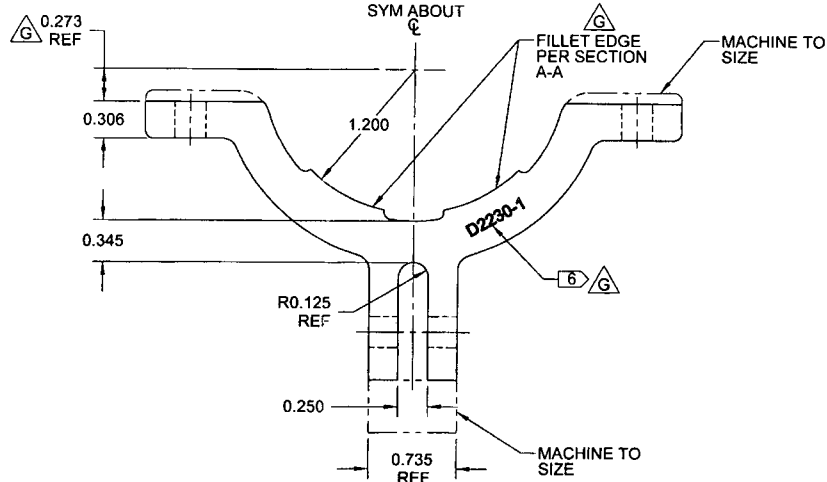
2

1



R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A D4-2
SCALE 2X



D2230-1 MOUNTING LUG

W6 59115

RELEASED
09/06/25/10

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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8

7

6

5

4

3

2

1

W/O:		WORK ORDER CHANGES					
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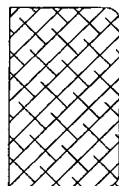
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

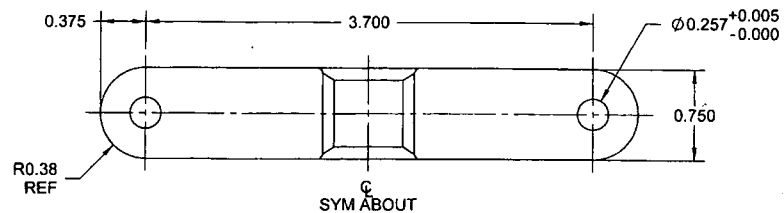
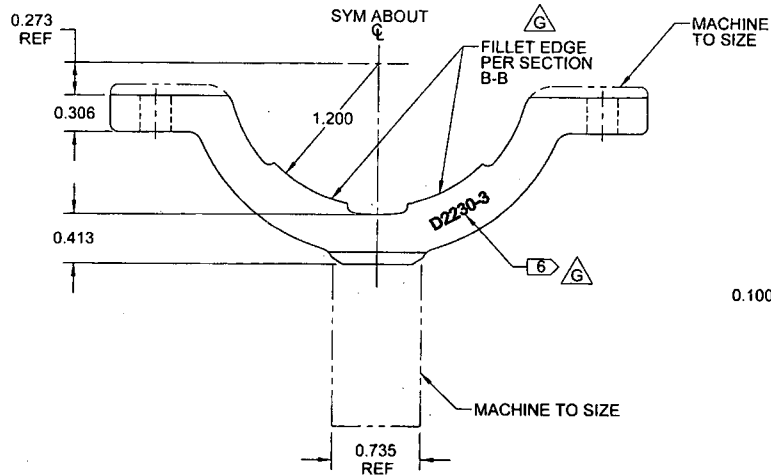
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SECTION B-B D4-3
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

W105945

RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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